

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017857**Date Inspected:** 10-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

WELDING

Segment # 11AW ~ 11BW (Base metal Repair)

This QA inspector observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11B-004; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate Transverse CJP Weld. The Critical Welding Repair Report (CWRR) was B- CWR1842. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM Repair-1 See the attached Photo.

Segment # 10CE

This QA inspector observed ZPMC qualified welding personnel identified as 040320 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG064C-006; located On Orthotropic Box Girder (OBG) Floor

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Beam to Longitudinal Diaphragm CJP Joint. The Welding Repair Report (WRR) was B- WR15764. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM- Repair-1. See the attached Photo.

Segment # 10CE

This QA inspector observed ZPMC qualified welding personnel identified as 040320 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG064C-057; located On Orthotropic Box Girder (OBG) Floor Beam to Longitudinal Diaphragm CJP Joint. The Welding Repair Report (WRR) was B- WR15768. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM- Repair-1. See the attached Photo.

Segment # 11AW

This QA inspector observed ZPMC qualified welding personnel identified as 041713 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW11L-003; located On Orthotropic Box Girder (OBG) Deck Plate to Connection Plate CJP Weld. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 11BW

This QA inspector observed ZPMC qualified welding personnel identified as 040611 perform Flux Core Arc Welding (SMAW), weld joint identified as OBW11L-005; located On Orthotropic Box Girder (OBG) Deck Plate to Connection Plate CJP Weld. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 10BE

This QA inspector observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW), weld joint identified as Retro-B1-10BE-039; located On Orthotropic Box Girder (OBG) Retro Plate to T-Rib Joint. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-TC-P5-FCM-1.

Segment # 10BE ~ 10CE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that Zhenhua Port Machinery Company (ZPMC) Quality Control (QC) personnel had performed Magnetic Testing (UT) on Side Plate to Side Plate Transverse CJP Weld in OBG segment 10BE~ 10CE.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
